

FIG.1

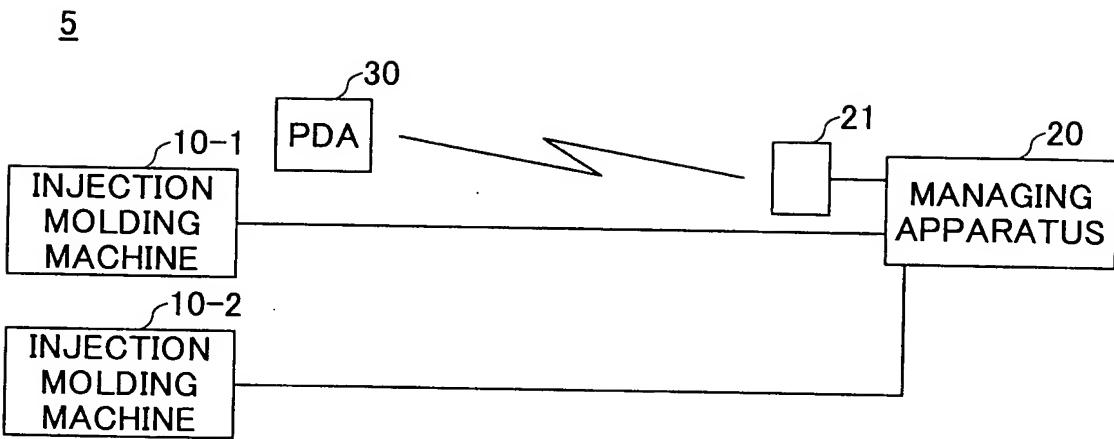


FIG.2

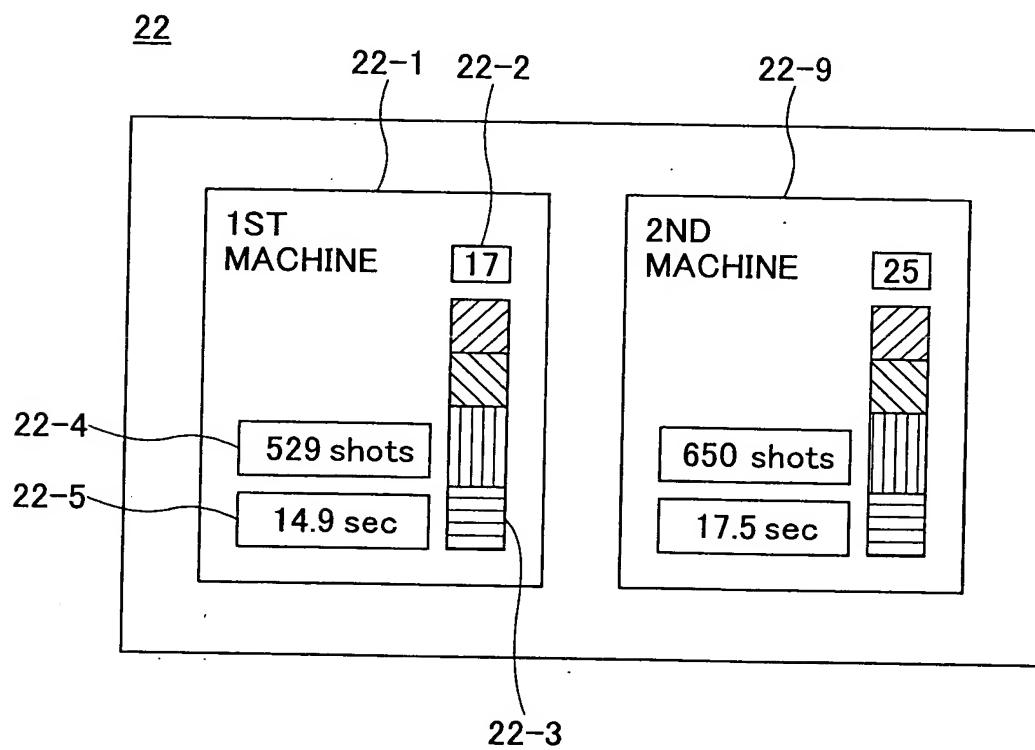


FIG. 3

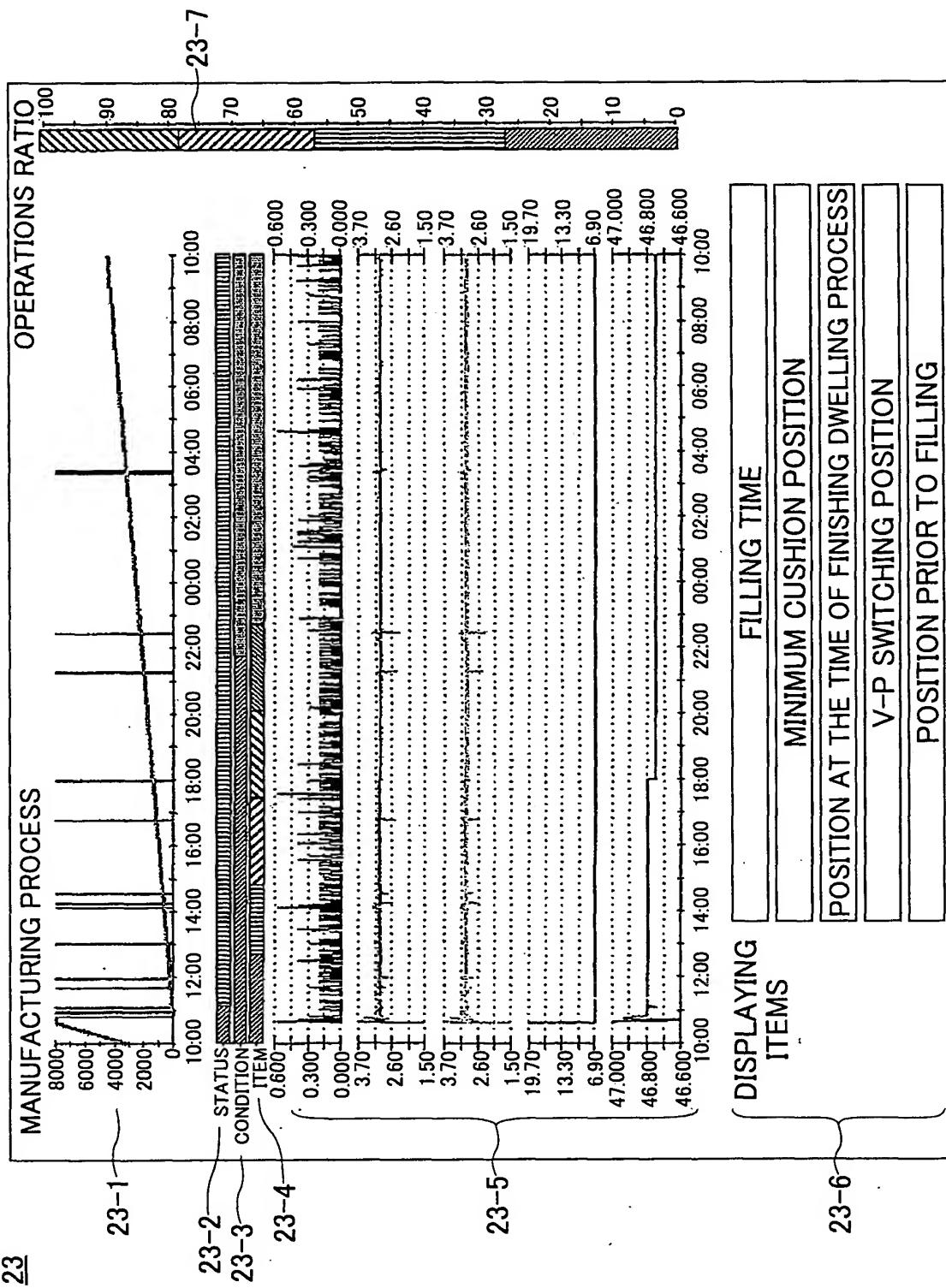


FIG.4

24

1ST MACHINE			
ITEMS	BEFORE CHANGED	AFTER CHANGED	DATE AND TIME
METERING FINISHING POSITION	46.25	46.20	2003/06/05 14:15:20
CYCLE MONITOR MODE	0	1	2003/06/05 10:20:15
MOLD PROTECTION MONITOR MODE	0	1	2003/06/05 10:20:15
MAXIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15
MINIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15

24-1 24-2 24-3 24-4

FIG.5

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1ST MACHINE		
ITEMS	TIME OF OCCURRENCE OF ABNORMALITY	TIME OF LIFTING OF ABNORMALITY
[ABNORMALITY] MOLD PROTECTION	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] SAFETY DOOR OPEN	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] NOT FINISHED MOLD CLAMPING ADJUSTMENT	2003/06/01 10:20:15	2003/06/02 14:15:10

25-1

25-2

25-3

FIG.6

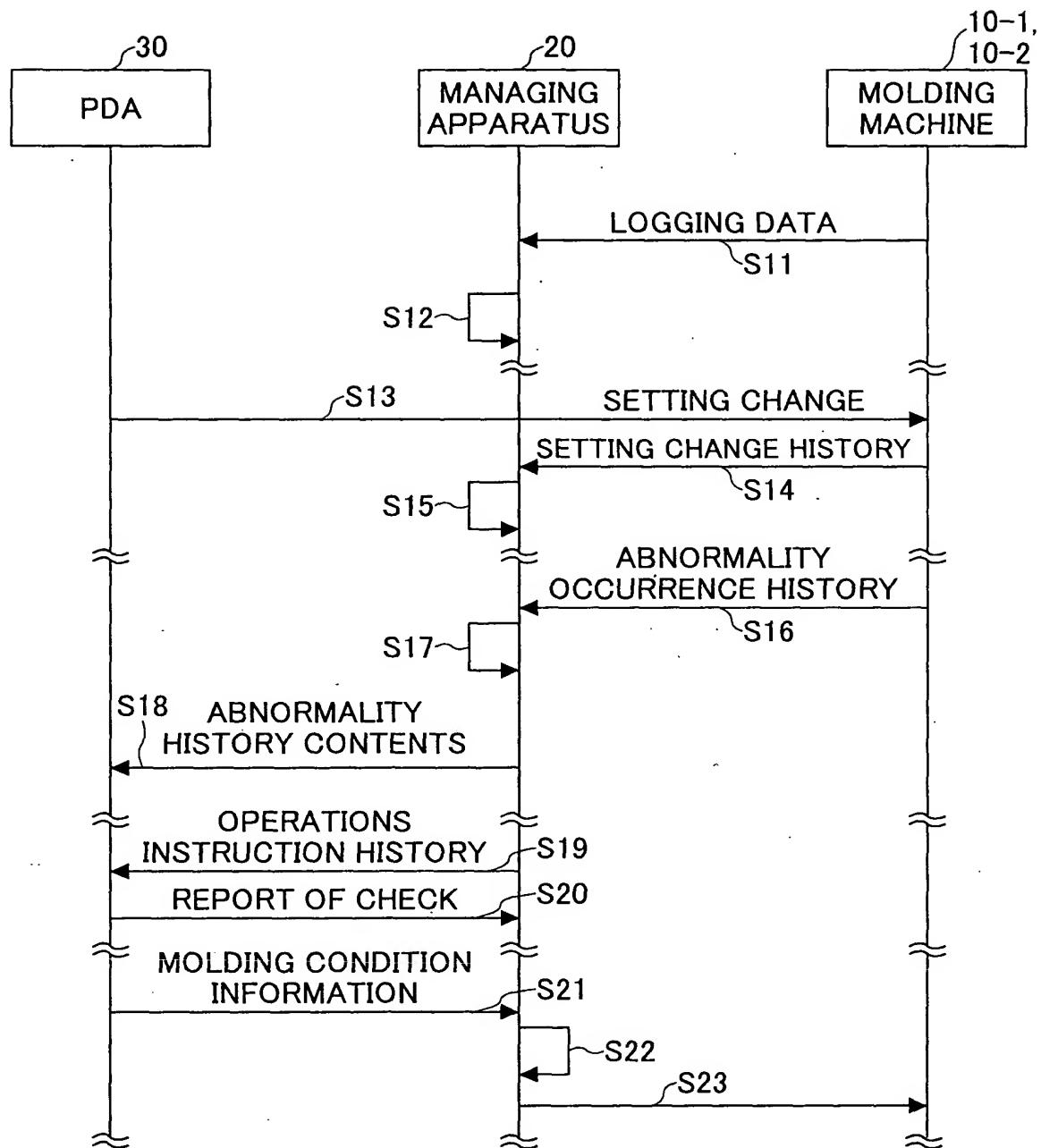


FIG.7

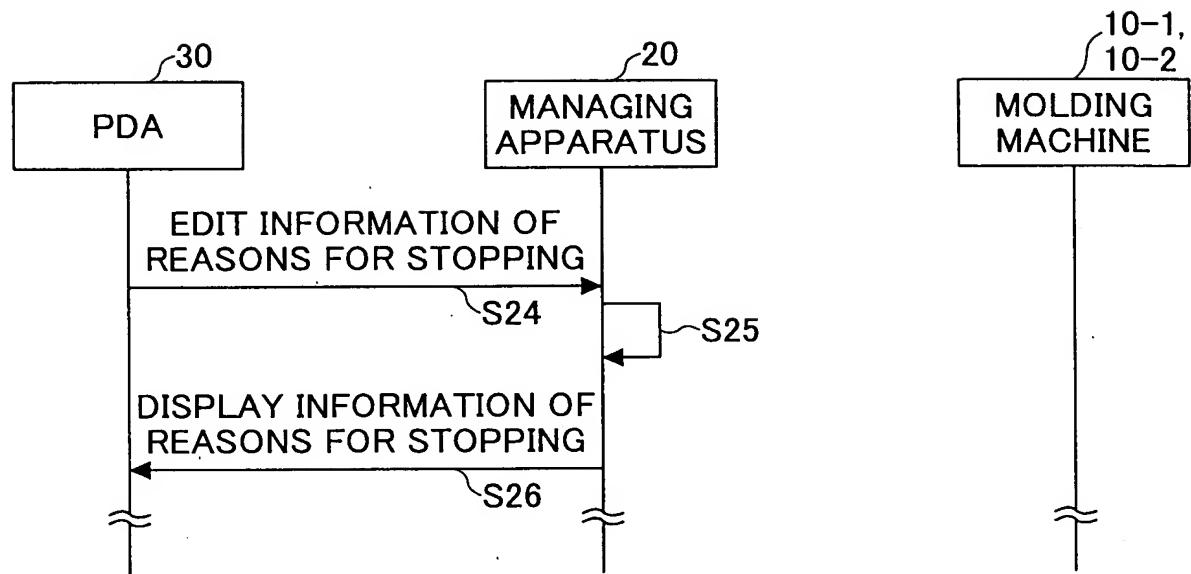


FIG.8

60

61	61	62
▲	▼	EDIT
1ST MACHINE		
MOLDING CONDITION		INITIAL
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING 000:01:15
OCCURRENCE TIME		03/05 11:06:09
RESTART TIME		03/05 11:07:24
ABNORMALITY		[A000]CYCLE
SUPPLEMENT		MOLD PROTECTION ABNORMALITY
PERIPHERAL APPARATUS		MOLD
REASON		PIN IS BROKEN
OPERATOR		× × × ×
MEMO		REPAIRABLE

FIG.9

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		MANUFACTURING INSTRUCTION
OPERATOR		× × × ×
1ST MACHINE		MOLDING MACHINE
<input type="button" value="▲"/> <input type="button" value="▼"/>		<input type="button" value="EDIT"/> <input type="button" value="RETURN"/>
PRODUCT	FLOWERPOT	
MOLDING CONDITION	FLOWERPOT AB	
MOLD	FLOWERPOT 001	
MATERIAL	PP	
ESTIMATED MANUFACTURED NUMBER	1000	

FIG.10

80

OPERATOR × × × ×	
81	1ST MACHINE <input type="button" value="▼"/>
82	<input type="button" value="SELECT"/> <input type="button" value="MENU"/>

FIG.11

85

86

REGISTER	OPERATOR × × × ×		
1ST MACHINE			
MOLDING CONDITION		INITIAL	
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING	000:01:15
OCCURRENCE TIME		03/05 11:06:09	
RESTART TIME		03/05 11:07:24	
ABNORMALITY		[A000]CYCLE	
SUPPLEMENT		MOLD PROTECTION ABNORMALITY <input checked="" type="checkbox"/>	
PERIPHERAL APPARATUS		MOLD <input checked="" type="checkbox"/>	
REASON		PIN IS BROKEN <input checked="" type="checkbox"/>	
MEMO		REPAIRABLE	